

Work Order ID 109039

Wednesday, November 06, 2013 10:45:28 A

D4543-3
B109039

109039

ASAP Page 1

Item ID: D4543-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Retainer, Outer, LH

Start Date: 11/6/2013 Start Qty: 22.00

22

Cust Item ID:

Required Date: 11/14/2013 Req'd Qty: 22.00

22

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *12-11-06*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4543

B

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1- Cut as per dwg

Prog rev: *B*

Dwg rev: *B*

2- Deburr

28

0

Jm 13-11-6

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

28

0

Jm 13-11-6

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Wednesday, November 06, 2013 10:45:28 A

Item ID: D4543-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Retainer, Outer, LH

Stop *NS2*

Start Date: 11/6/2013 Start Qty: 22.00

22

Cust Item ID:

Required Date: 11/14/2013 Req'd Qty: 22.00

22

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
9-89

B1106

28

can

130

0.00

130

Small Fab

Memo

0.00

Small Fab

FORM ON BEAD ROLLER (DT9787)

***MAKE ONE AND ENSURE IT'S MADE AS PER DWG BEFORE
MAKING QTY REQUIRED ON W/O***

28

FF
13-11-07

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

DAS
27
9-89

B1108

28

can

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109039

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Wednesday, November 06, 2013 10:45:28 A

Item ID: D4543-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Retainer, Outer, LH

Stop *NS2*

Start Date: 11/6/2013 Start Qty: 22.00

22

Cust Item ID:

Required Date: 11/14/2013 Req'd Qty: 22.00

22

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

Chemical Conversion Coat per QS1005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

28 W613.11.7

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

28x DAS 26 9-89

B-11-8

170

Identify as per dwg & Stock Location: 81528

0.00

170

Packaging

Memo

0.00

Packaging

28 DAS 26 9-89

B-11-8

Work Order ID 109039

109039

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Wednesday, November 06, 2013 10:45:28 A

Item ID: D4543-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Retainer, Outer, LH

Stop *NS2*

Start Date: 11/6/2013 Start Qty: 22.00

22

Cust Item ID:

Required Date: 11/14/2013 Req'd Qty: 22.00

22

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

[Handwritten signature]
PL13-11-08
ME
13-11-08

Picklist Print

Wednesday, November 06, 2013 10:45:27

Page 1

Work Order ID: 109039
Parent Item: D4543-3
Parent Item Name: Retainer, Outer, LH

Start Date: 11/6/2013 Required Date: 11/14/2013
Start Qty: 22.00 Required Qty: 22.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B 12.02.24 as per dwg
reva DD verf:EC IPP REV:C 13.04.23 as per dwg revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032 6061-T6 Sheet 0.032"		Purchased	No			100	sf	619.9160	1.144				

Location

Loc Qty

Loc Code

MAT021

619.916

123483

256.15

m125822

48.1

m126115

60.356

m126309

69.31

m127272

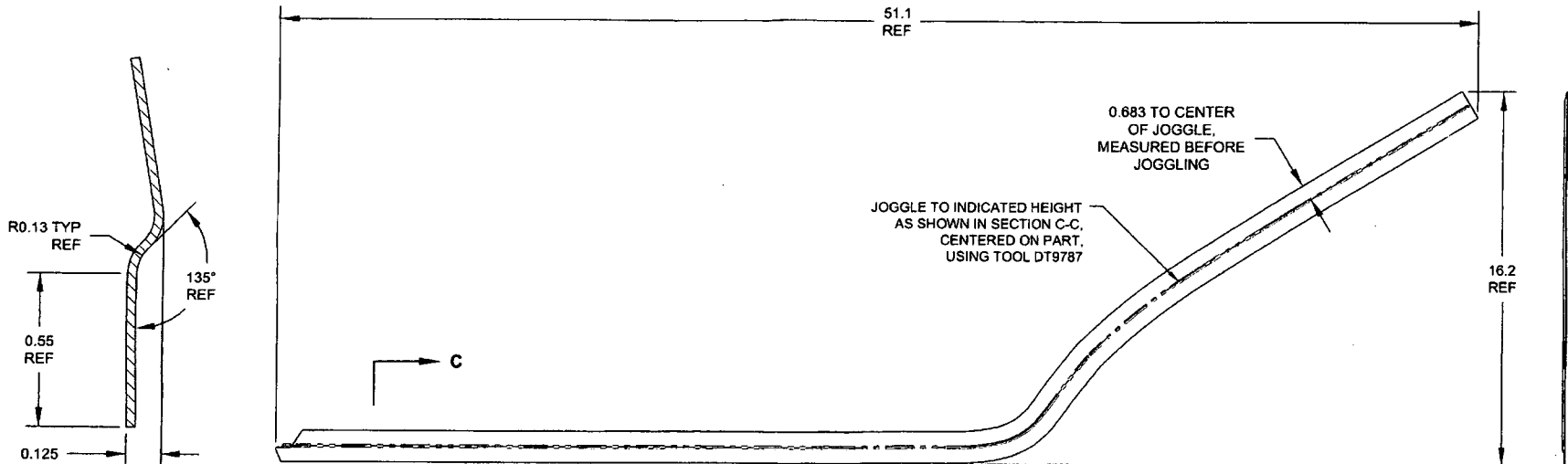
186

127272

32

11/13-11-6

mf
13-11-06
#409039



SECTION C-C
JOGGLE DETAIL
SCALE 12X

D4543-3 RETAINER, LH OUTER
(SIDE/TOP)

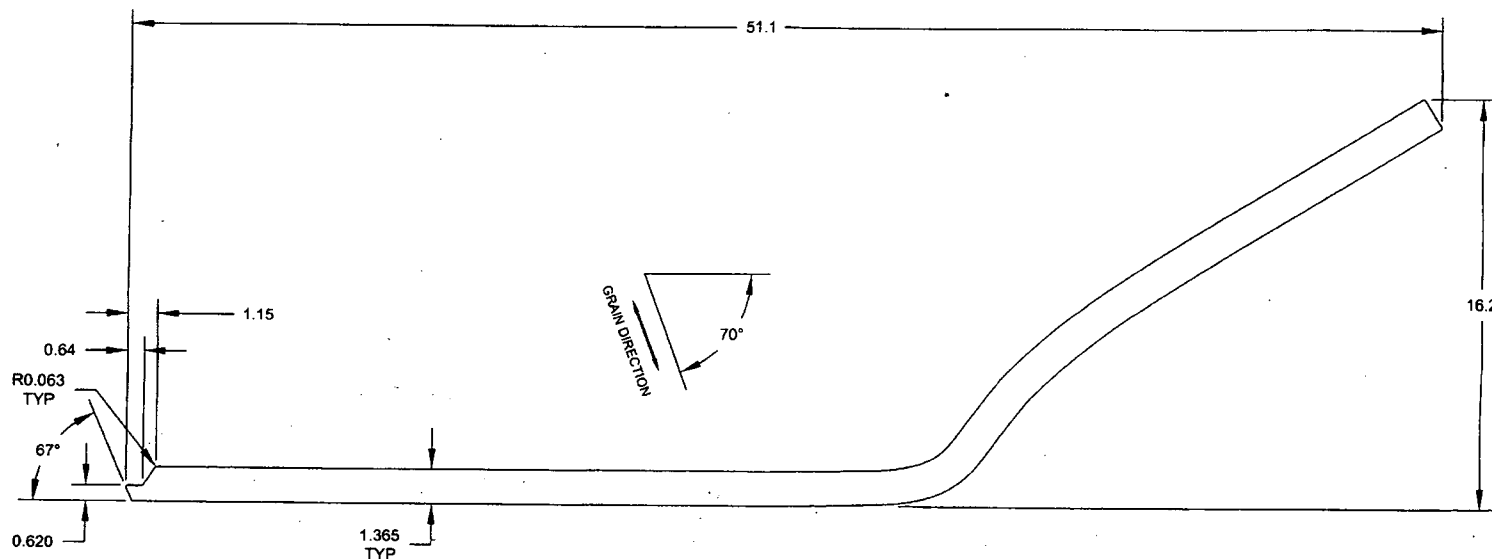


RELEASED
2013-04-22

NOTES:

- 1) MATERIAL: MAKE FROM D4543-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	90		
CHECKED	AL	DRAWING NO.	REV. B
MFG. APPR.	AL	D4543	SHEET 4 OF 9
APPROVED	AL	TITLE	SCALE
DE APPR.	AL	RETAINER, OUTER	NTS
DATE	13.04.15	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4543-3F FLAT PATTERN



RELEASED
2013-04-22
MD

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs
- 8) PROFILE PER DRAWING FILE "D4543-3F-REVB.DXF"

DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	90		
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	AA	D4543	SHEET 6 OF 9
APPROVED	MP	TITLE	SCALE
DE APPR.	#	RETAINER, OUTER	NTS
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